



Dart Aerospace Ltd.
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D2565-111
Job Sheet 209658



Part No: D2565-111

Job Qty: 4 pcs

Part Name: Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/5/20

Job Tracking No:

Due Date: 5/27/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV E IPP: E 01.06.04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21 EC
IPP: E

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Small Fab - Brake NC 13.90	4 pcs	5/26/20	0.25	0.62	Small Fab - Brake - 1		DAS 58 9-89	MAY 07 2020	
						Small Fab - Brake - 2				
						Small Fab - Brake - 3				
110	Small Fab - 2 - B4B	4 pcs	5/26/20	0.00	0.47	Small Fab - 1 - B4B		DAS 58 9-89	MAY 11 2020	
						Small Fab - 2 - B4B				
						Small Fab - 3 - B4B				
						Small Fab - 4 - B4B				
						Small Fab - 5 - B4B				
						Small Fab - 6 - B4B				
						Small Fab - 7 - B4B				
						Small Fab - 8 - B4B				
						Small Fab - 9 - B4B				
120	QC 5	4 pcs	5/26/20	0.00	0.00	Small Fab - Various 1 - B4B		DAS 40 9-89	20-05-12	
						QC 5 - 10				
						QC 5 - 12				
						QC 5 - 17				
						QC 5 - 18				
						QC 5 - 19				
						QC 5 - 22				
						QC 5 - 24				
						QC 5 - 3				
						QC 5 - 43				
						QC 5 - 49				
						QC 5 - 51				
						QC 5 - 58				
						QC 5 - 68				
						QC 5 - 9				
						QC 5 - 50				
						QC 5 - 30				
						QC 5 - 40				

Plex 5/5/20 9:43 AM Dart.Renwick.Jennife

130 Powdercoat - 2 White GI(S)- B4B	4 pcs	5/27/20	0.00 0.11	QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
140 QC 3	4 pcs	5/27/20	0.00 0.00	Powdercoat - 3 - B4B	20-05-14
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	20-5-15
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
150 Packaging 3-1 - Stock - B4B	4 pcs	5/27/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	20-05-19
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	

234
0-89DAS
15
0-89DAS
28
9-89

20-05-19

					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
160	QC 21 - SA	4	5/27/20	0.00 0.00	QC 21 - SA - 21	DAS
		pcs			QC 21 - SA - 70	21
					QC 21 - SA - 53	9-88
Part Op 100 - Punch as per Dwg D2565 using DT 8313 Deburr Descriptions: 110 - Small Fab - Deburr 120 - QC5- Inspect part completeness to step on W/O 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel START TIME: _____ FINISH TIME: _____ 140 - QC3- Inspect Part Finish 150 - Identify as per dwg & Stock Location: _____ 160 - QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M304TR0.750W.049	304 Round Tube .750 X .049W	4.5500 ft (1.1375 ea)	100-Small Fab - Brake NC		5269180	
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Small Fab - Brake NC	M304TR0.750W.049	5	388	0		
Part Specifications						
Specifications could not be found.						

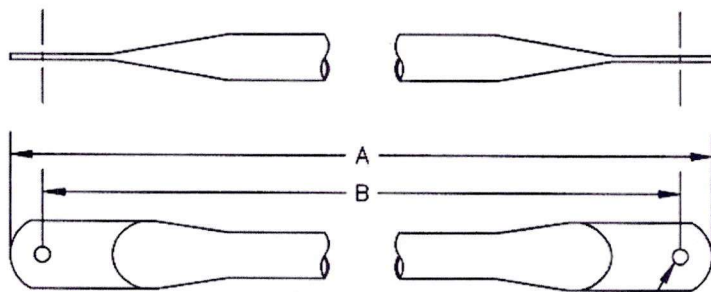
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DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05

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WITHOUT NOTICE
WORK ORDER
NO. 209658



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐						Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation				Disposition													
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance ☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread ☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up ☐													
				Other/Details:													
				Completed By													
				Lead hand / Supervisor													
				QC / QA Coordinator													



Container No: S276379



Part: D2565-111

Job No: 209658

Serial No/Batch: S276379

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA

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